



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

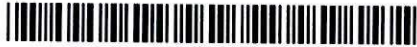
31 July
D2010-104
Job Sheet 180201



Part No: D2010-104

Job Qty: 4 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/2/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 04.02.17 New issue KJ/JLM IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC IPP
Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Small Fab-4		DAS 58
100	Brake NC	4 pcs	7/20/18	7/20/18	0.00	1.30	Brake NC 3		9-89 DAS 58 17/7/18
110	Small Fab	4 pcs	7/20/18	7/20/18	0.00	1.00	Small Fab-1		DAS 58 9-89
120	Small Fab	4 pcs	7/20/18	7/20/18	0.00	0.82	Small Fab-1		DAS 58 9-89
130	QC	4 pcs	7/20/18	7/20/18	0.00	0.00	QC5		38 9-89
140	Powdercoat	4 pcs	7/20/18	7/20/18	0.00	0.12	Powdercoat4		38 9-89
150	QC	4 pcs	7/20/18	7/20/18	0.00	0.00	QC3		38 9-89
160	Packaging	4 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1	51351 98	JUL 25 2018
170	QC21-SA	4 Ea	7/20/18	7/20/18	0.00	0.00	QC21		DAS 21 JUL 25 2018

Part Op 100 - Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104

Descriptions: 110 - 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- flare before installing plug as per dwg D2010 3- Install D2057 plug as per Dwg D2010

120 - 1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010

140 - START TIME: *10:10* OVEN TEMPERATURE: *300° FINISH 10:40*

M 158700.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.049	304 Round Tube .500 X .049W	6 ft (1.5 ea)	90-Start up Operation	<i>5030909</i>
D2057	Plug	4 Ea (1 ea)	110-Small Fab	<i>5030909</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR0.500W.049	6	112	0
110-Small Fab	D2057	4	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	7.900inches ± 0.030	7.930 7.870		
2	Arm	10.200 ± 0.030			
3	Arm	45.000Degree ± 0.500	45.500		

			44.500
4	Arm	45.000Degrees ± 0.500	45.500
			44.500
5	Arm	0.600inches + 0.008 - 0.001	0.608 0.599

Plex 7/3/18 7:03 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION				AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date: _____		Step #: _____		QTY Effective: _____		Disposition					
						Completed By					
						Lead hand / Supervisor Approval Verification					
						QC / QA Coordinator Approval					

Environment		Root	
Design	☐	Design	☐
Doc/Data	☐	Doc/Data	☐
Equip/Tooling	☐	Equip/Tooling	☐
Handling/Pre	☐	Handling/Pre	☐
Material	☐	Material	☐
Internal Transport	☐	Internal Transport	☐
Tribal Knowledge	☐	Tribal Knowledge	☐
LOA	☐	LOA	☐
Substation	☐	Substation	☐
Past Expiry Date	☐	Past Expiry Date	☐
Misidentified	☐	Misidentified	☐

Poor Information		Crushing	
Rushing	☐	Heat Treat	☐
Product Improvement	☐	Wave/Twist in Tube	☐
Process Improvement	☐	Marks/Chatter	☐
Manufacturing Process	☐		☐
Past Due	☐		☐

OTHER: _____	
---------------------	--

Power Loss/Surge		Positioned Wrong	
Folio/Program	☐	Outside Dimensions	☐
Grain	☐	Over/Under tolerance	☐
Weld	☐	Part Incorrect	☐
Wrong Stock Pulled	☐	Part Lost/Missing	☐
Out of Sequence	☐	Part Moved	☐
Off-set	☐	Drawing	☐
Mislabeled	☐	Finish	☐
Fit/Function	☐	Misread	☐
Misaligned/off center	☐	Turning Sequence	☐

DART AEROSPACE	
Container No: S095943	
Part: D2010 - 104	
Job No: 180201	
Serial No/Batch: S095943	
Revision: _____	
Inspector: _____	
Exp Date: _____	
Instructions: Various STC's	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/25/18